

Work Order ID 51585 -2

August 27, 2009 8:24:33 AM



Page 1

Item ID: D3572-041
Revision ID: A
Item Name: Guide Assembly

Accept



Setup Start



Stop



Start Date: 8/27/09 Start Qty: 5.00
Required Date: 9/11/09 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

Date: 08-27-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3572

Rev A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SP 09.08.31

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut Tube D3572-1 as per Dwg D3572: 2-deburr both ends

SP 09.08.31

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 509/08/31

(15) 4

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Page 2

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Required Date: 9/11/09 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

LARGE FABRICATION RESOURCE 1: 1-Weld D3572-3 guides and D3572-5
bracket as per Dwg D3572- A/R AL ROD

Batch: M111385

M111385

~~07.07.22~~

EL

9-10-14

(Y2)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 809/10/14

(10) 4

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

PD 09.10.14

(2)



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Start Date: 8/27/09 Start Qty: 5.00
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Reference:

Accept



Setup Start
Stop



Cust Item ID:
Customer:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Small Fab

Small Fab

Small Fab

Memo

1- grind weld flush at the end of tube only

0.00

0.00

EL

9-10-14



170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 8/21/14



✓

180



HandFinish

Hand Finishing

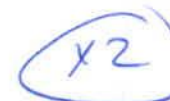
Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

=> 9/10/14



✓

Work Order ID 51585

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Page 4

Item ID: D3572-041
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Accept



Setup Start



Stop



Start Date: 8/27/09 Start Qty: 5.00
Required Date: 9/11/09 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

190



Powdercoat
Powder Coating

Operation
Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

START TIME:

8:20AM

FINISH TIME:

OVEN TEMPERATURE:

320°F

M1109091

7 JH 09/10/15 (X2) Ø

200



QC
Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Ø 09-10-15

Ø

210



Packaging
Packaging

Identify as per dwg & Stock Location:

260

0.00

Memo

0.00

09/10/16

Ø

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Page 5

Item ID: D3572-041
Revision ID: A
Item Name: Guide Assembly
Start Date: 8/27/09
Required Date: 9/11/09
Reference:

Accept



Setup Start



Stop



Start Qty: 5.00
Req'd Qty: 5.00



Cust Item ID:
Customer:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

220



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

09/10/19 *[Signature]*

mk
09-10-19

Picklist Print

August 27, 2009 8:24:33 AM

Page 1

Work Order ID: 51585

Parent Item: D3572-041RevA

Parent Item Name: Guide Assembly

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3572-3RevD		Manufactured	No				Each	16.0000	20.0000			
Guide												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

47804

16

16

Each

5.0000

5.0000

D3572-5RevD

Manufactured

No



Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32415

5

5

f

2.6300

11.7059

M6061T6T1.000W.188

Purchased

No



6061T6 RD TUBE 1.00 X .188W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

2.63

109041

1.03

18101

1.6

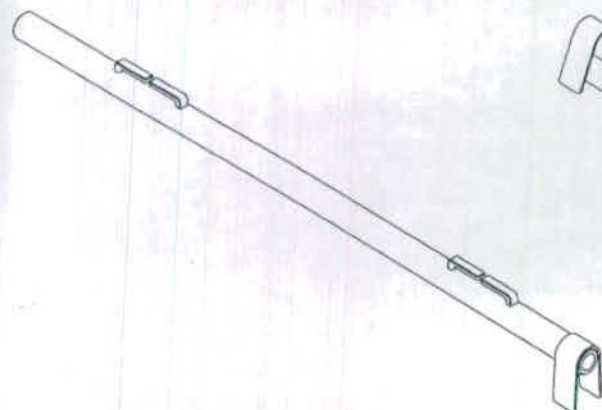
m 112529.

SP 9.8.31

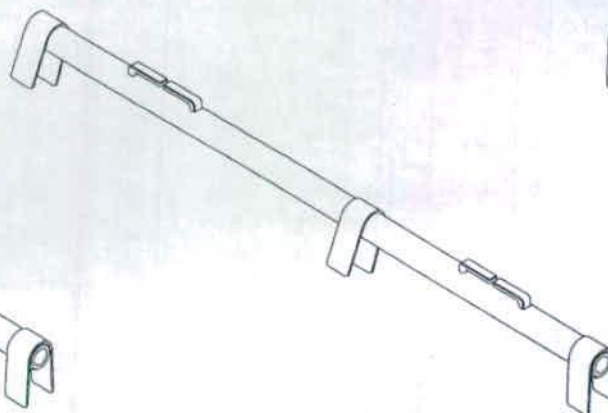
EL 9-10-14

EL 9-10-14

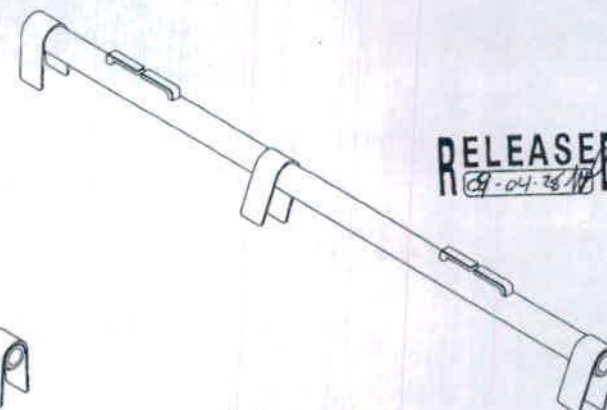
ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

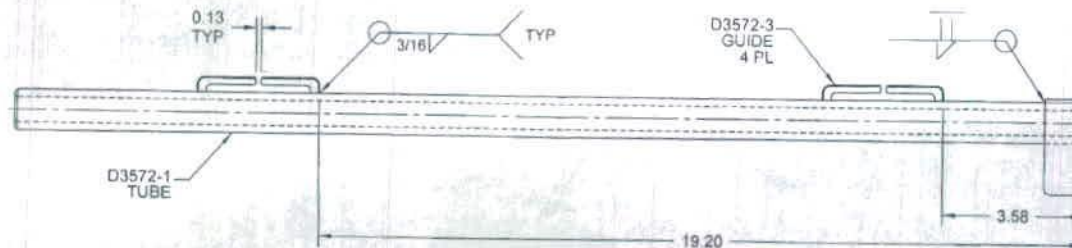
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09-04-25/18

NOTES:

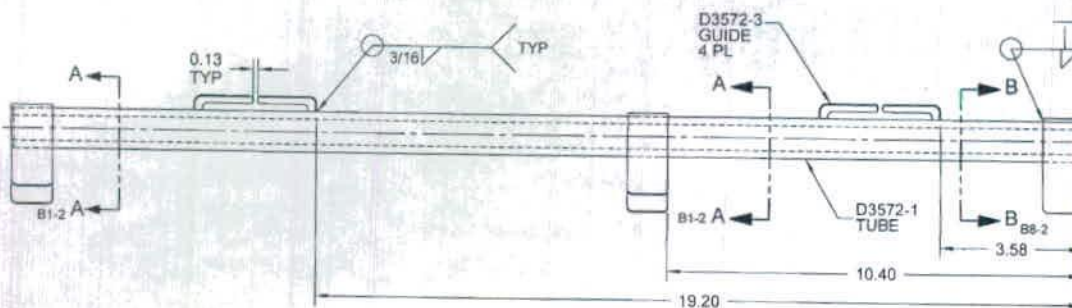
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

51585

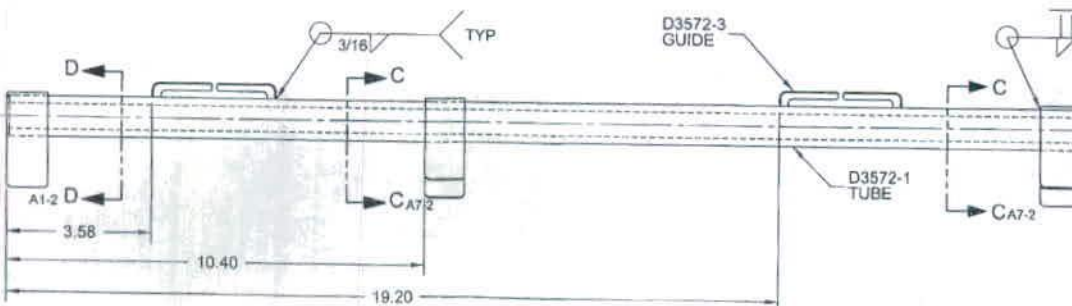
D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS, ADD -043, -044 FOR UH-1, SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A	DRAWING NO.	REV. D
MFG. APPR.	CE	D3572	SHEET 1 OF 4
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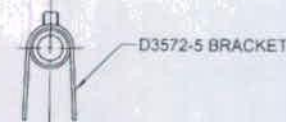
D3572-041 GUIDE ASSEMBLY



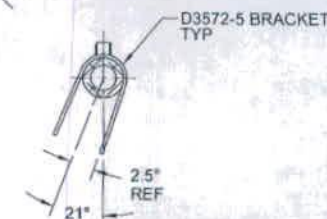
D3572-043 GUIDE ASSEMBLY



D3572-044 GUIDE ASSEMBLY



D3572-5 BRACKET



SECTION A-A C7-2
(2 PL) C4-2

RELEASED
09.04.17



D3572-5 BRACKET
TYP

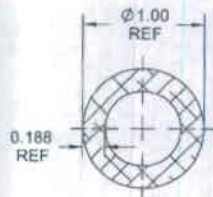
SECTION D-D A7-2

SECTION B-B C2-2

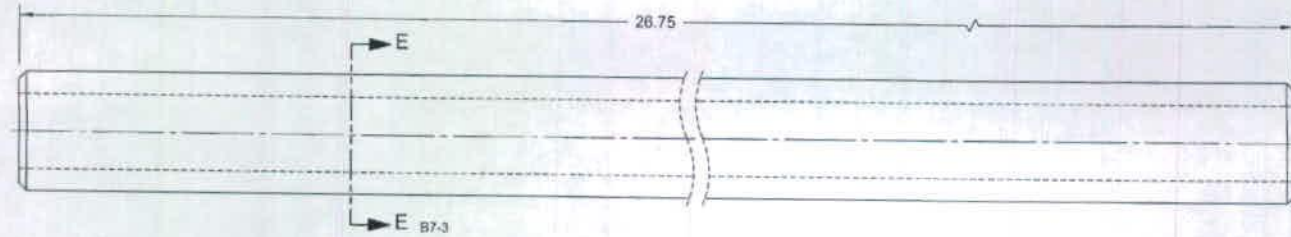
SECTION C-C A2-2
A5-2

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO	REV. I
MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GUIDE ASSEMBLY	NTS
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SECTION E-E CS-3



D3572-1 TUBE

0.06 X 45° CMF MIN

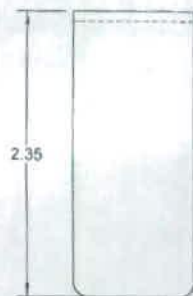
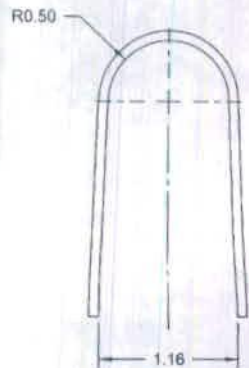
D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

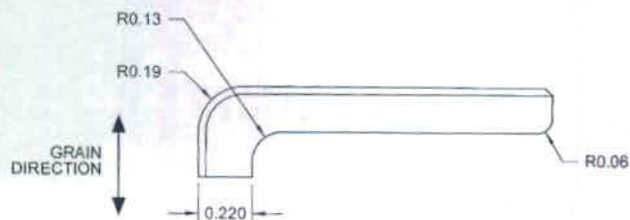
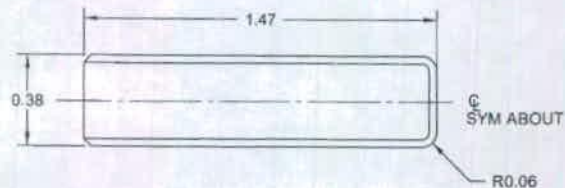
RELEASED
07/04/17

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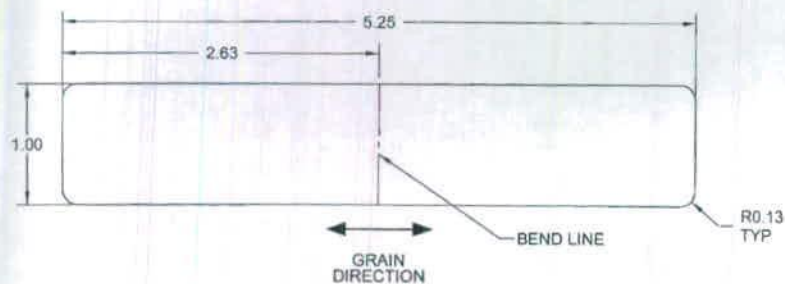
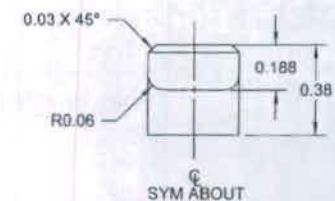
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DRAWN	A.S		
CHECKED	A	DRAWING NO.	REV. D
MFG. APPR.	C	D3572	SHEET 3 OF 4
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D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-3 GUIDE



D3572-5F FLAT PATTERN

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3572	SHEET 4 OF 4
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9/2/18

51585

